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D5068-041

Job Sheet 194974



Part No: D5068-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, LH/RH

Order 14818



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/14/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: D5068 REV.A IPP REV:A 17.08.30 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Basket - 1	1 pcs	6/14/19		0.00	20.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-89
							Large Fab - 8		
120	QC 9	1 pcs	6/14/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		DAS
							QC 9 - 24		24
							QC 9 - 43		9-89
							QC 9 - 50		
130	QC 5	1 pcs	6/14/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		DAS
							QC 5 - 3		24
							QC 5 - 43		9-89
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
140	Handfinish - 2-1 Pressure-B4B	1 pcs	6/14/19		0.00	0.25	QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
150	Powdercoat - 2 White Gl(S)-B4B	1 pcs	6/14/19		0.00	0.50	Handfinish - 2 - 1 - B4B		
							Handfinish - 2 - 2 - B4B		
							Handfinish - 2 - 3 - B4B		
							Handfinish - 2 - 4 - B4B		
150	Powdercoat - 2 White Gl(S)-B4B	1 pcs	6/14/19		0.00	0.50	Powdercoat - 1 - B4B		
							Powdercoat - 2 - B4B		

START: 3:45 OUT 3:55 FINISH: 4:00

Plex 5/13/19 8:28 AM Dart Renwick Jennifer

BX 19-5-30

160 QC 3	1 pcs	6/14/19	0.00 0.00	Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	ML 19-5-31
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
170 Handfinish - 4-1-Assembly-B4B	1 pcs	6/14/19	0.00 0.25	Handfinish - 4 - 1 - B4B	ML 19-5-31
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
180 QC 5	1 pcs	6/14/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS
				QC 5 - 3	19
				QC 5 - 43	9-8
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	19
				QC 5 - 9	9-8
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Packaging 3-1 - Stock - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

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DAS
15
9-89DAS
19
9-8DAS
19
9-8

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200	QC 21 - SA	1	6/14/19	0.00	0.00
		pcs			
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - (Weld per dwg A/R S.S. rod Batch: _____) 1- Assemble ribs , weld as per dwg D5068 using DT9610A Descriptions: ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D5068 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- Weld hinge (3) and Mounting brackets as per dwg D5068 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg 120 - (QC9- Inspect visual per QSI004- Fusion Welds) 130 - (QC5- Inspect part completeness to step on W/O) 140 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) 150 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat 2-Mask this area prior to finish section A-A, B-B 3-1ST COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Assemble as per dwg) ASSEMBLE BLANKING PLATE AND BUMPER AS PER DWG 180 - (QC5- Inspect part completeness to step on W/O) 190 - (Identify as per dwg & Stock Location: _____) 200 - (QC21- Final Inspection - Work Order Release)					

009869

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	110-Large Fab - Basket - 1	5178393
D3913-1	Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5172797
D3913-15	Wide Handle Plate	1 pcs (1 ea)	110-Large Fab - Basket - 1	5155103
D3913-3	Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5178251
D3913-9	Hinge Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5178219
D3916-041	Rib Assembly	2 pcs (2 ea)	110-Large Fab - Basket - 1	5181983
D3916-5	Light Rib	2 pcs (2 ea)	110-Large Fab - Basket - 1	5179611
D4016-1	Hinge Half, Base	3 pcs (3 ea)	110-Large Fab - Basket - 1	5121276
D4017-7	Rib	3 pcs (3 ea)	110-Large Fab - Basket - 1	5173533
D4020-11	End Mesh, Basket	2 pcs (2 ea)	110-Large Fab - Basket - 1	5179084
D4021-1	Handle Plate	3 pcs (3 ea)	110-Large Fab - Basket - 1	5179504
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	110-Large Fab - Basket - 1	5181473
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	110-Large Fab - Basket - 1	5181719
D4672-1	Blanking Plate	2 pcs (2 ea)	110-Large Fab - Basket - 1	5160068
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	110-Large Fab - Basket - 1	5181090
D4785-117	Rib Assembly	2 pcs (2 ea)	110-Large Fab - Basket - 1	5141714
D5068-1	Rib	2 pcs (2 ea)	110-Large Fab - Basket - 1	5141678
D5068-3	Rib	2 pcs (2 ea)	110-Large Fab - Basket - 1	5181948
D5068-5	Rib	1 pcs (1 ea)	110-Large Fab - Basket - 1	5034063
AN3-10A	Bolt	6 Ea (6 ea)	170-Handfinish - 4-1-Assembly-B4B	5179612
D2931	Bumper	2 pcs (2 ea)	170-Handfinish - 4-1-Assembly-B4B	516643
D4021-5	Blanking Plate	2 pcs (2 ea)	170-Handfinish - 4-1-Assembly-B4B	5170064
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-Handfinish - 4-1-Assembly-B4B	5155664
MS21042L3	Nut	6 Ea (6 ea)	170-Handfinish - 4-1-Assembly-B4B	5157167
NAS1149F0332P	Washer	12 Ea (12 ea)	170-Handfinish - 4-1-Assembly-B4B	5153776
NAS1149DN832J	Washer	2 Ea (2 ea)	170-Handfinish - 4-1-Assembly-B4B	5136362

DAS
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2-89

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Basket - 1	D2581	2	28	0
	D3913-1	1	13	0
	D3913-15	1	6	0
	D3913-3	1	7	0
	D3913-9	1	12	0
	D3916-041	2	9	0
	D3916-5	2	22	0
	D4016-1	3	36	0
	D4017-7	3	58	0
	D4020-11	2	14	0
	D4021-1	3	36	0
	D4034-041	1	2	0
	D4034-043	1	2	0
	D4672-1	2	13	0
	D4785-117	2	2	0
	D5068-1	2	4	0
	D5068-3	2	0	0
170-Handfinish - 4-1-Assembly-B4B	D5068-5	1	3	0
	M304EX0.75-16F	33	717	0
	AN3-10A	6	345	0
	D2931	2	723	0
	D4021-5	2	22	0
	MS20600-AD4W3	2	370	0
	MS21042L3	6	2,860	0
	NAS1149DN832J	2	365	0
	NAS1149F0332P	12	4,639	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S184507



Part: D5068 - 041

Job No: 194974

Serial No/Batch: S184507

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

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Plex 5/13/19 8:28 AM Dart.Renwick.Jennifer

Date: 05/28/19